

Work Order ID 56527

March 1, 2010 9:28:38 AM



Page 1

Item ID: D2583

Accept



Setup Start



Revision ID:

Stop



Item Name: Latch Bracket

Start Date: 3/01/10 Start Qty: 40.00



Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 40.00



Customer:

Reference:

Run Start

Approvals: Process Plan: 

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2583	Rev B

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2583 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

56527.040

1B 10-3-10



110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

1B 10-3-10

120



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

8/10/03 1/10



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2583

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Item Name: Latch Bracket

Start Date: 3/01/10 Start Qty: 40.00

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Deburr Form on CNC Brake as per Dwg D2583

0.00

0.00

JB 10/03/11

40

0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

JB 10/03/11

40

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

BR 10-3-15

40

W/O:		WORK ORDER CHANGES						
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Item ID: D2583

Revision ID:

Item Name: Latch Bracket

Start Date: 3/01/10 Start Qty: 40.00

Required Date: 3/05/10 Req'd Qty: 40.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME:

2:20pm

FINISH TIME:

OVEN TEMPERATURE:

320°F

⇒ JV 10/03/16

(X40) φ

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

pk 10-3-16

(40) φ

180



Packaging

Packaging

Identify as per dwg & Stock Location: 018

0.00

Memo

0.00

Pk 10/3/16 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D2583

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Item Name: Latch Bracket

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Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

190



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Memo

0.00

10/03/24

B 10-22-3
410

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March 1, 2010 9:28:37 AM

Page 1

Work Order ID: 56527

Parent Item: D2583

Parent Item Name: Latch Bracket

Comments: IPP: C00.11.01 Removed P/O for Powder Coat- in house process DM
IPP: D06.07.21 Waterjet EC

Start Date: 3/01/10

Required Date: 3/05/10

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	79.0568	4.9221	6.2		
5052-H32 .040 Sheet												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	79.0568	
101875	6.625	
104921	3.3568	
106900	2	
107513	4.5	
109058	35.675	
113123	26.9	

113123

1810-310

50

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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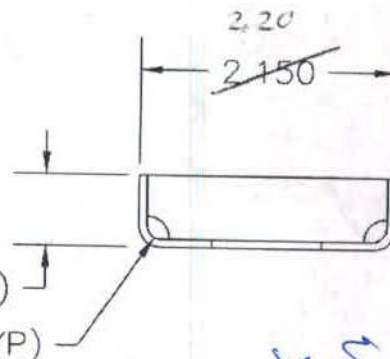
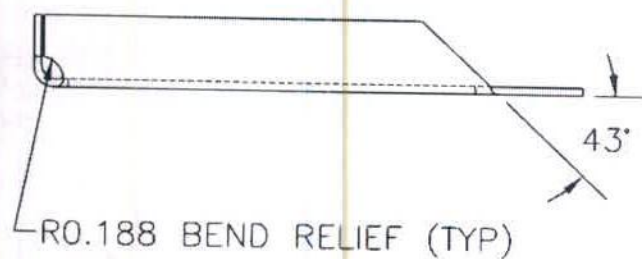
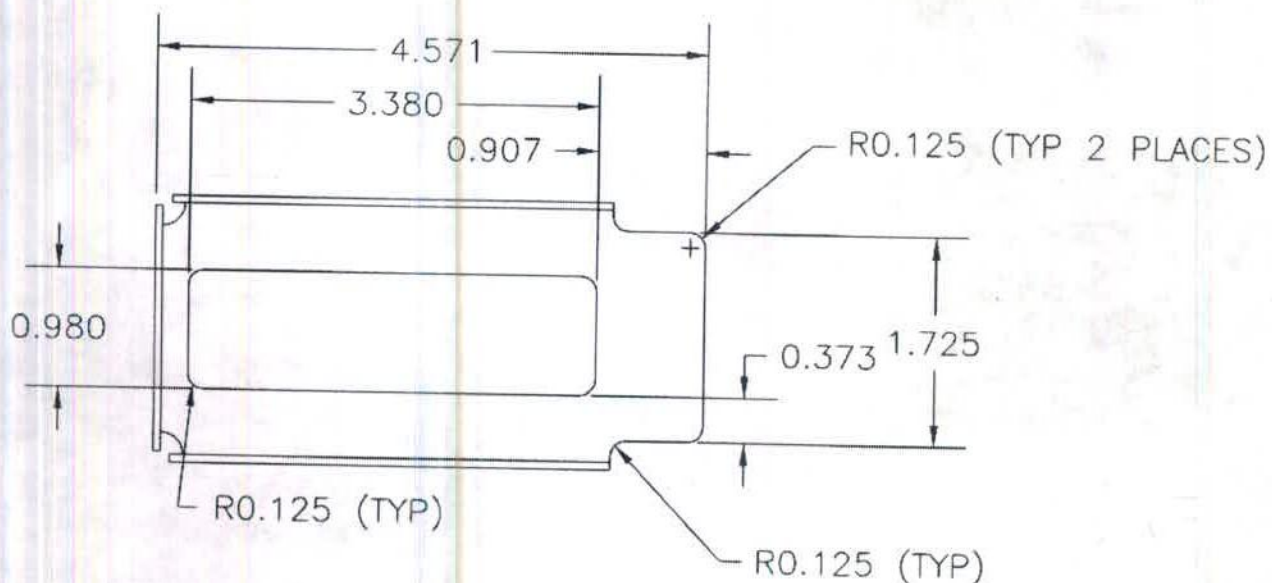
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DART**RELEASED**
KE 99.02.25*56527*

DESIGN	DATE	CHECKED	DRAWN BY	DRAWING NO.	TITLE	REV. B	SHEET 1 OF 1	SCALE
MIKE M.	99.02.22	KE	RF	D2583	LATCH BRACKET			2:1
A	96.07.10			NEW ISSUE				
B	99.02.22			CHANGE OF FINISH (PER TSR A887)				

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

